

Date: Tuesday, 5/23/2006 2:31:00 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STUB COVER
Job Number : 27233 -1	
Estimate Number : 12415	
P.O. Number : N/A	Part Number : D34941
This Issue : 5/23/2006 S.O. No. : N/A	Drawing Number : D3494 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 5/30/2006
Checked & Approved By : SEE ABOVE WORK ORDER	Qty: 10 ea. Um: Each
Continue... Est Rev. A New Issue 06-05-18 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.6972 sf(s)/Unit Total : 2.7888 sf(s)
304/316 .063 Sheet
(M304S16GA)
Batch: M7106 (2) M19059 (6) 5.10 06:05:24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3494
Dwg Rev: A
Prog Rev: A

SAD 06:05:24

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 06:04:24 (4)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 06:04:24 (4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Form as per Dwg D3494

SAD 06/05/24

(1) ATO

May, 5/23/2006 2:31:00 PM
da Lacelle

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: STUB COVER

Job Number: 27233

Part Number: D34941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20-05-25 (1)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3494

A/R SS ROD Batch: *M100372*

06/05/25 (1)

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06-05-25 (1)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

06-05-25 (1)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/05/25 (1)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *11A*

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21


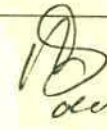
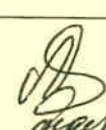
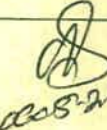
06/05/25 (1)

Job Completion



06-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/05/24		Piece Dimension don't match with the drawing (New Predet)		3 serps + replace	CL 06/05/24	 06/05/24	 06/05/24	 06/05/24

* No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

& initial all entries

QA: N/C Closed: _____ Date: _____

RT AEROSPACE LTD Description: Inspection Dwg:	Work Order: 27233 Part Number: D34941 Rev: Page 1 of 1
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FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.643	±0.010	8.645	✓		Vern	
8.318	±0.010	8.310	✓		Vern	
7.920	±0.010	7.918	✓		Vern	
6.201	±0.010	6.202	✓		Vern	
6.152	±0.010	6.155	✓		Vern	
6.103	±0.010	6.105	✓		Vern	
2.540	±0.010	2.544	✓		Vern	
2.491	±0.010	2.496	✓		Vern	
2.442	±0.010	2.446	✓		Vern	
0.723	±0.010	0.720	✓		Vern	
0.325	±0.010	0.327	✓		Vern	
1.723	±0.010	1.724	✓		Vern	
1.768	±0.010	1.770	✓		Vern	
3.223	±0.010	3.232	✓		Vern	
3.566	±0.010	3.568	✓		Vern	
7.506	±0.010	7.509	✓		Vern	
7.848	±0.010	7.852	✓		Vern	
9.303	±0.010	9.308	✓		Vern	
9.348	±0.010	9.358	✓		Vern	
11.071	±0.010	11.081	✓		Vern	
Ø0.208	+0.005/-0.001	Ø0.210	✓		Vern	
R0.25	±0.010	R0.25	✓		Radius gauge	
R0.05	±0.010	R0.05	✓		Radius gauge	

Measured by: <u>SAD/PC</u>	Audited by: <u>[Signature]</u>	Prototype Approval:	
Date: <u>06.05.24</u>	Date: <u>06.05.25</u>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

